



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

649.5013
Job Sheet 165556



Part No: 649.5013

Job Qty: 8 ea

Part Name: Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/2/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP REV:A NEW ISSUE 13-09-24 RQ VERIFIED BY:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
649.5013 Deflector	DWG REV D IPP REV:A NEW ISSUE 13-09-24 RQ VERIFIED BY:JLM		0.000	
649.5013E Deflector	DWG REV D		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	8 Ea	10/30/17	0.00	0.00	Start up container	
100	Bandsaw	8 pcs	10/30/17	0.00	0.00	Bandsaw1	
110	CNC Vertical Machining	8 pcs	10/31/17	0.00	3.14	HAAS 1	
120	QC	8 pcs	10/31/17	0.00	0.00	QC2	
130	QC	8 pcs	10/31/17	0.00	0.00	QC8	
140	Outsource	8 pcs	10/31/17	0.00	0.00	Outsource4	
150	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging2	
155	QC	8 pcs	10/31/17	0.00	0.00	QC5	
180	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging3	
190	QC21-SA	8 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Cut Blank at 7.500"

Descriptions: 110 - 1-Machine per folio FB212 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges
140 - Issue P/O to ATG: 38497 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV**
Primer 1.9 mils

EX 17-11-15
SPR 11-28
SPR 11-28
AT
DEC 05 2017
NOV 22 2017
9-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	649.5013E	5	0	0	0

Part Specifications

Specifications could not be found.



S014908



Deflector

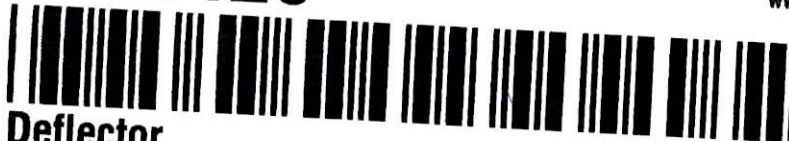
PART NO: 649.5013
Revision:
Operation: Outsource
Change No:

Mfg Date: 11/28/17
Job No: 165556

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



S009126



Deflector

PART NO: 649.5013
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/13/17
Job No: 165556

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Work Order ID 165556***165556***

Page 1

Monday, August 28, 2017 11:40:01 AM

Item ID: 649.5013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deflector

Start Date: 9/7/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/3/2017 Req'd Qty: 8.00

8

Customer:

Reference:

DAS

21

9-99

Approvals: Process Plan: _____ Date: **AUG 29 2017**

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

649.5000

D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 7.500"

8

Ø

SBL 17/11/13

110

0.52

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.78

HAAS CNC vertical machine #1

1-Machine per folio FB212

DWG REV: _____

FOLIO REV: _____

8

Ø

SBL 17/11/13

2- deburr and break all sharp edges

Monday, August 28, 2017 11:40:01 AM

Page 2

Quality Control

Work Order ID 165556***165556***

Page 3

Monday, August 28, 2017 11:40:01 AM

Item ID: 649.5013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deflector

Start Date: 9/7/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/3/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG: _____

AS PER MPP-172 SECTION 2.1,
HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2AS PER MPP-172 SECTION 4.2,
PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N

Certification of Comformity is required

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

Work Order ID 165556

165556

Page 4

Monday, August 28, 2017 11:40:01 AM

Item ID: 649.5013

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Deflector

Start Date: 9/7/2017

Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/3/2017

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Monday, August 28, 2017 11:40:04 AM

Work Order ID: 165556

165556

Parent Item: 649.5013

649 5013

Parent Item Name: Deflector

Start Date: 9/7/2017

Required Date: 10/3/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-09-24 RQ VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
649.5013E		Manufactured	No			100	f	103.8340	0.625	5.263158			
649 5013F									**				
Deflector													
										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
										MAT035	103.834		
										92313	103.834		
												<u>4,958</u>	17/11/13 SBL

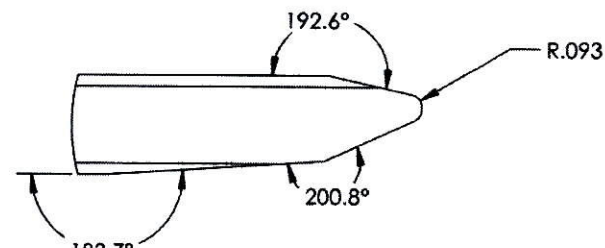
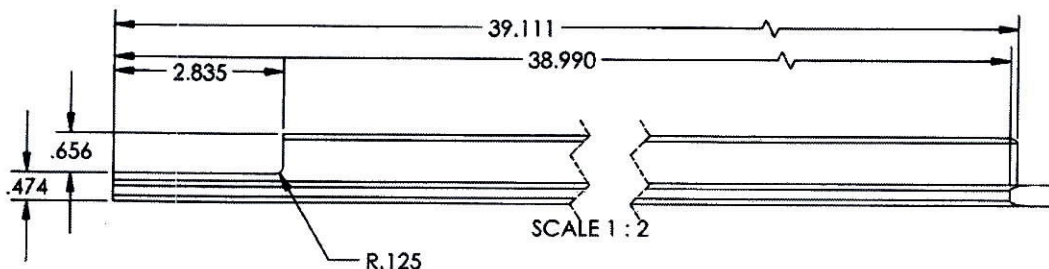
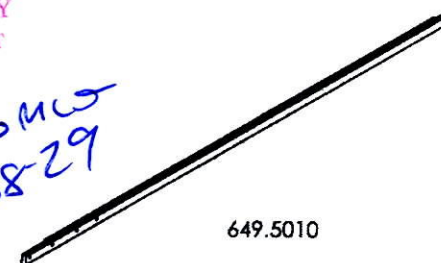
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NOTES: UNLESS OTHERWISE SPECIFIED

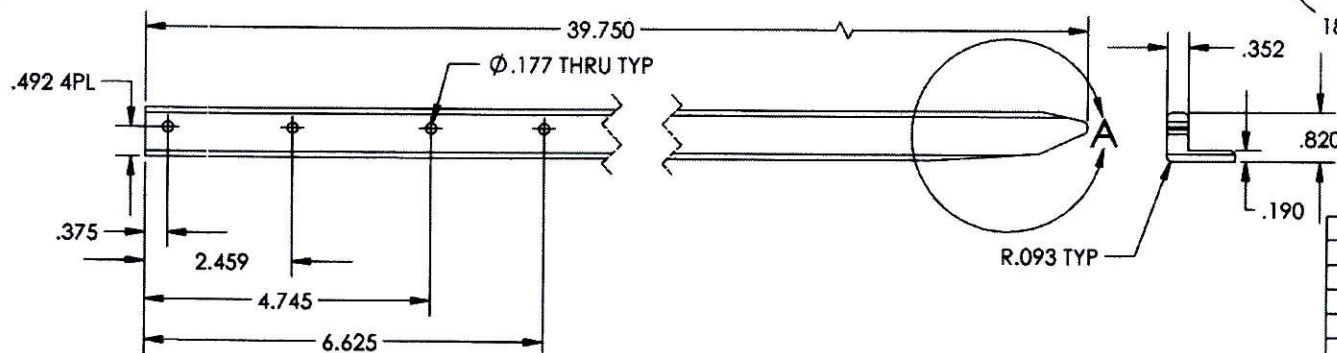
- 1 PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.
- 2 FINISH: ANODIZE IAW MPP-172 SECTION 2.1;
PRETREAT IAW MPP-172 SECTION 3.1;
PRIME IAW MPP-172 SECTION 4.2; 1-2 MIL MAX.
3. DE BURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.
5. ALL DIMENSIONS SHOWN PRIOR TO FINISH.
- 6 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5010 DEFLECTOR.SLDPRJT, LAST MODIFIED 04-16-12.
- 7 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5012 DEFLECTOR.SLDPRJT, LAST MODIFIED 11-03-11.
- 8 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5013 DEFLECTOR.SLDPRJT, LAST MODIFIED 04-16-12.
- 9 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: 649.5014 DEFLECTOR.SLDPRJT, LAST MODIFIED 04-04-17.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165556 MLC
170829

REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	11-03-11	P. BRAVO
A	INCORPORATED ECH 03427 AND 03478	04-16-12	P. BRAVO
B	INCORPORATED ECH 03504	05-02-12	P. BRAVO
C	INCORPORATED ECH 03521	05-22-12	P. BRAVO
D	INCORPORATED ECH 04240, 03493 & 03720	04-04-17	P. BRAVO



DETAIL A
SCALE 1:1



5	649.5014	DEFLECTOR	△	△△
4	649.5013	DEFLECTOR	△	△△
3	649.5012	DEFLECTOR	△	△△
2	649.5011	DEFLECTOR	△	△
1	649.5010	DEFLECTOR	△	△△
FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

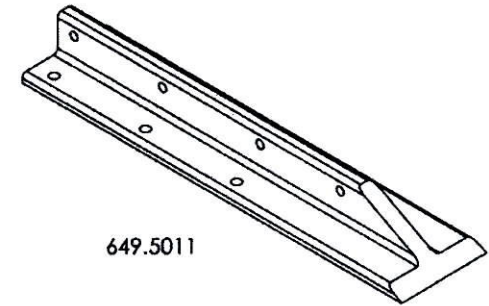
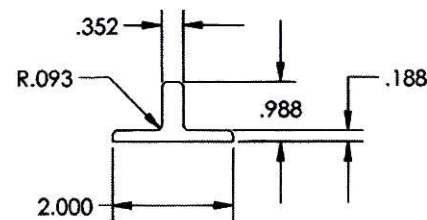
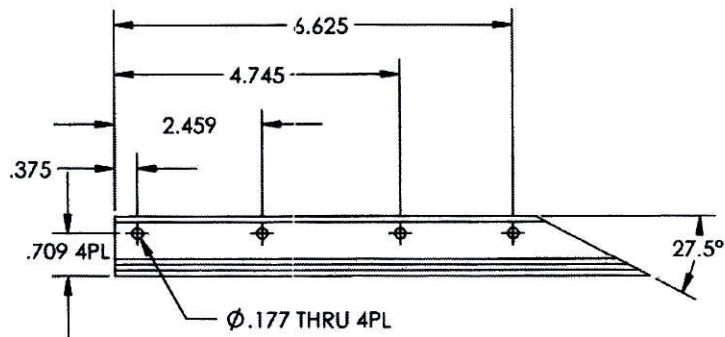
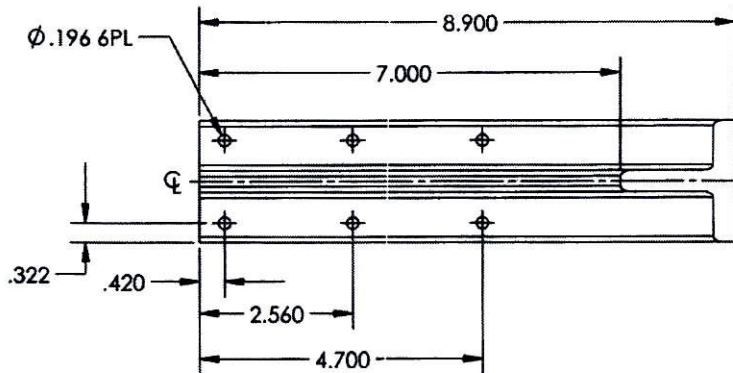
QTY	ORIGINAL DATE	REVISION	DATE	DESCRIPTION
649.4700	11-03-11	11-03-11		
	DRAWN BY	CHECKED		
	A. QUINN	P. BRAVO		
	DRAWING APPROVAL			
	P. BRAVO			
	CONTRACT NO.			
	UNLESS OTHERWISE SPECIFIED			
	DIMENSIONS ARE IN INCHES			
	TOLERANCES ARE:			
	2 PLACE DECIMALS .00			
	3 PLACE DECIMALS .000			
	ANGLES .5°			
	SCALE	NONE		
	SHEET	1 OF 5		

DART 3030 ENTERPRISE CT.,
SUITE A
VISTA, CA 92081
(760)-724-5300
APICAL INDUSTRIES INC.
DBA DART AEROSPACE

DEFLECTOR

REV. D
SCALE NONE
SHEET 1 OF 5

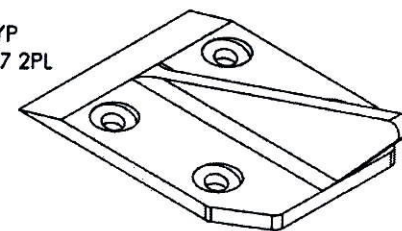
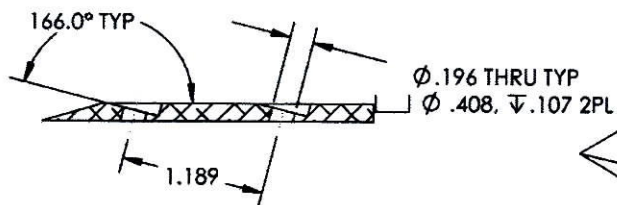
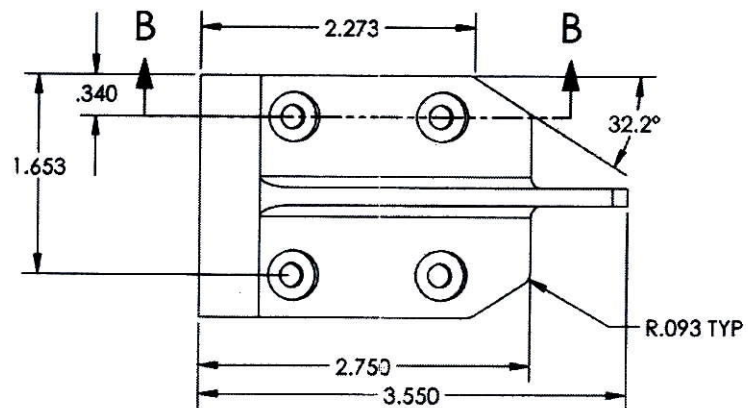
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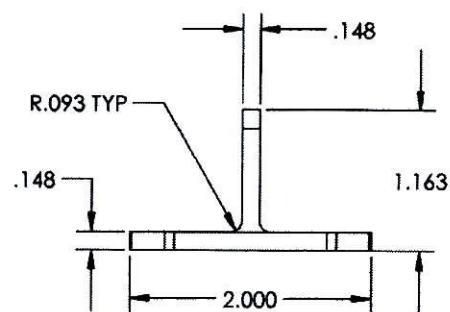
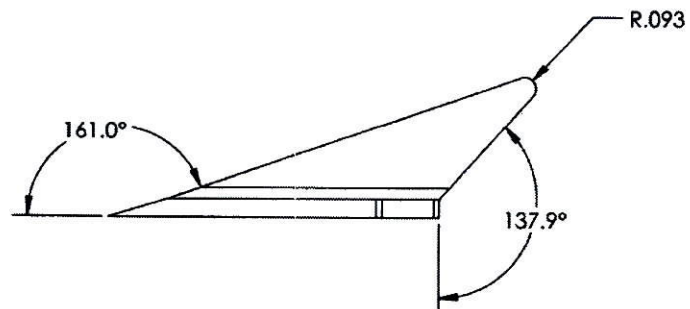
649.5011

ORIGINAL DATE 11-03-11		3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (760)-724-5300	
DRAWN BY A. QUAN	CHECKED BY P. BRAVO	DART AEROSPACE APICAL INDUSTRIES INC. DART AEROSPACE	
DRAWING APPROVAL P. BRAVO	DATE 11-03-11	DEFLECTOR	
CONTRACT NO.		SIR B	REV. D
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07M126	649.5000
SCALE NONE		SHEET 2 OF 5	

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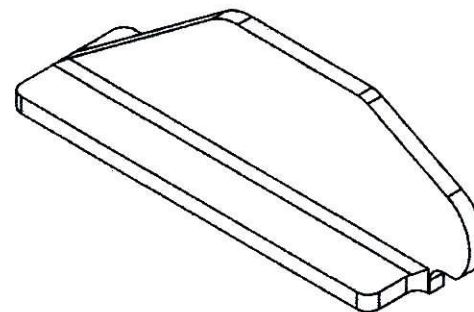
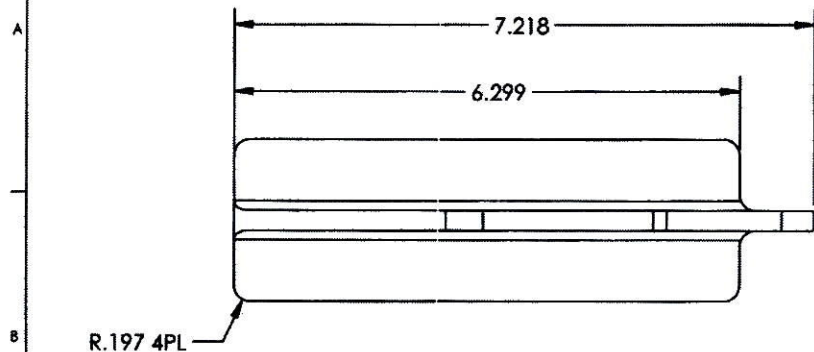


649.5012

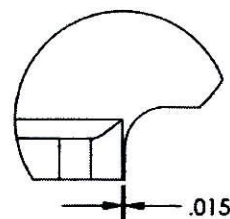
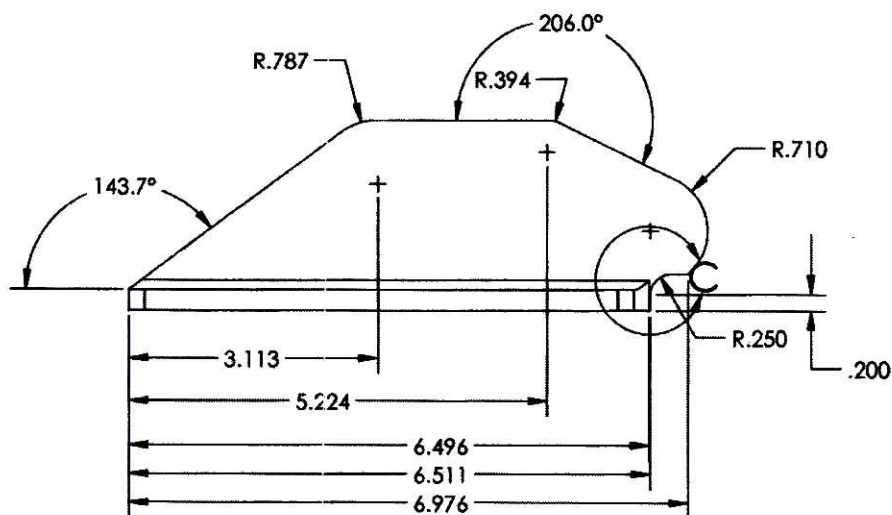


ORIGINAL DATE	11-02-11			3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760)-774-5300
DRAWN BY	A. GRAH			APICAL INDUSTRIES, INC. DBA DART AEROSPACE
CHECKED BY	P. BEAKO	DEFLECTOR		
DRAWING APPROVAL	P. BEAKO			
SUBMIT	03/05/02	SCALE NONE		
CONTRACT NO.				
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°				
REV	CAGE CODE	DWG. NO.	REV	
B	07M26	649.5000	D	
SCALE NONE			SHEET 3 OF 5	

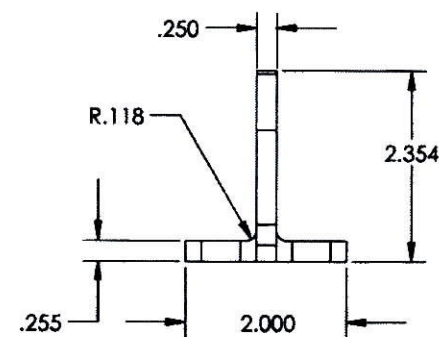
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649.5013

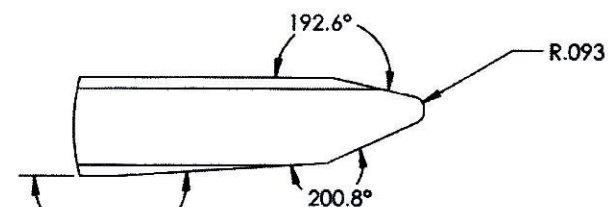
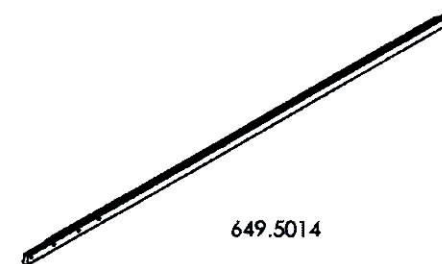
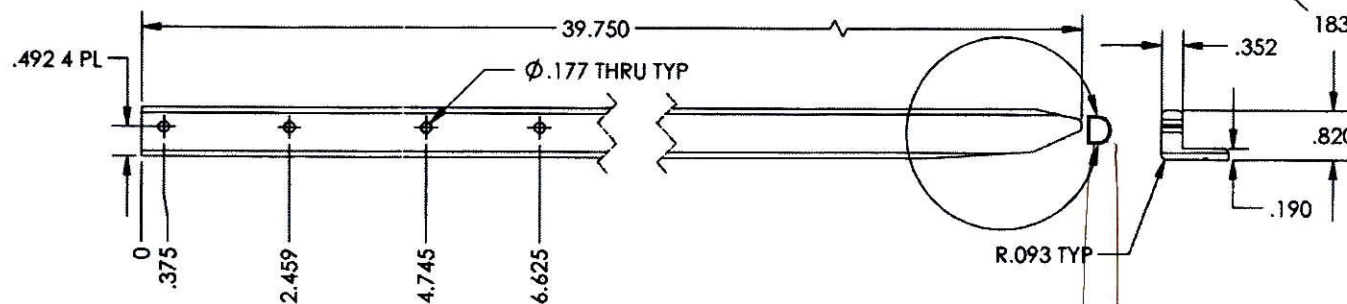
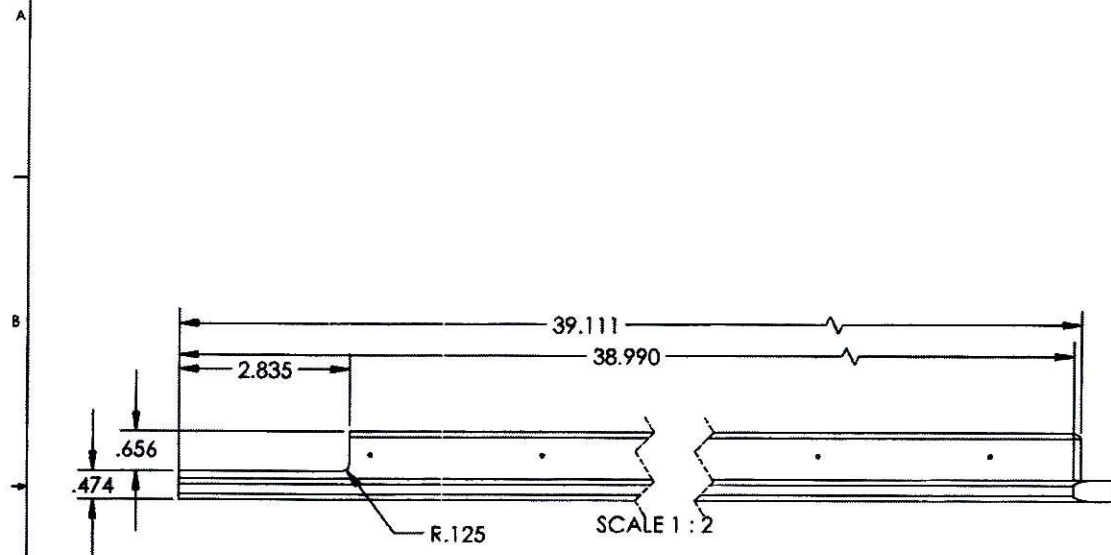


DETAIL C
SCALE 2:1.5



ORIGINAL DATE 11-03-11		3030 ENTERPRISE CT., SUITE A, VISTA, CA 92081 (760)-724-5300	
DRAWN BY A. GIBLIN	CHECKED P. MAYO	AFICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. MAYO		DEFLECTOR	
CONTRACT NO.		SHEET 8	REV. D
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ± .5°		DATE CODE 07M16	DWG. NO. 649.5000
SCALE: NONE		SHEET 4 OF 5	

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DETAIL D
SCALE 1:1

ORIGINAL DATE 11-09-11		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY A. GUAN		CHECKED P. MAYO	
DRAWING APPROVAL P. MAYO		APICAL INDUSTRIES INC. 3030 DART AEROSPACE	
CONTRACT NO.		DEFLECTOR	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SITE B	REV. D
SCALE: NONE		SHEET 5 OF 5	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038447

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038447

PO Date: 11/22/17

Due Date: 11/28/17

**Purchase Order
Revision:**

Revision Date: 11/28/17

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: PLEASE ADVISE IF POSSIBLE TO GET ALL
PART ANODIZE FOR NEXT MONDAY,
PARTS REQUIRED ASAP

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168640	649.4811	-	Clip ISSUE P/O: HARD ANODIZE COLOR BLACK/PRIME AS PER DWG 649.4811		Firmed	11/28/17	20 pcs	0 pcs	20 pcs	\$13.60/pcs	\$272.00
Line Item Note RUSH ORDER REQUIRED FOR NEXT MONDAY.												
2	165690	649.5011	-	Deflector Issue P/O to ATG: HARD ANODIZE COLOR BLACK,PRIME AS PER DWG 649.5011		Firmed	11/28/17	8 pcs	0 pcs	8 pcs	\$16.50/pcs	\$132.00
3	165556	649.5013	-	Deflector Issue P/O to ATG: HARD ANODIZE COLOR BLACK,PRIME AS PER DWG 649.5013		Firmed	12/4/17	8 pcs	0 pcs	8 pcs	\$17.60/pcs	\$140.80
4	168578	RBD29905-9	-	Pulley -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required		Firmed	11/28/17	7 pcs	0 pcs	7 pcs	\$19.63/pcs	\$137.41
5	166219	RBEM210V4000103-1	-	Base -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required		Firmed	11/28/17	1 pcs	0 pcs	1 pcs	\$13.35/pcs	\$13.35



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914187

Date: 28-Nov-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 649.4811 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22030		Rev: B PO: PO038447 Line: 1
8 ea	Part: 649.5011 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 22031		Rev: D PO: PO038447 Line: 2
8 ea	Part: 649.5013 ✓ Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 22032		Rev: D PO: PO038447 Line: 3
1 ea	Part: RBW6405G08832-3G-05 Locktube Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22036		Rev: PO: PO038447 Line: 7
1 ea	Part: RBW6405G08832-3G-07 Receiver Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22037		Rev: PO: PO038447 Line: 8
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914187

Date: 28-Nov-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>28/11/2017</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> <u>17-11-28</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 649.5013 Revision: Deflector														
90	Start up Operation	S009095	165556	0 Ea	0	S009095	Start Up Machining		WIP	11/13/2017	*			
		S009101	165556	0 Ea	0	S009101	Start Up Machining		WIP	11/13/2017	*			
		S009109	165556	0 Ea	0	S009109	Start Up Machining		WIP	11/13/2017	*			
Operation Totals:		3		0	0									
Part Totals:		3		0	0									
Part Number: 649.5013E Revision: Deflector														
140	QC21-SA FT	S009085	165556	8 ft	0	92313	Start Up Machining		WIP	11/13/2017	Issue Container			
Operation Totals:		1		8	0									
Part Totals:		1		8	0									
Totals:		4		8	0									

Plex 1/8/2018 1:03 PM Dart.Boucher.Sylvie